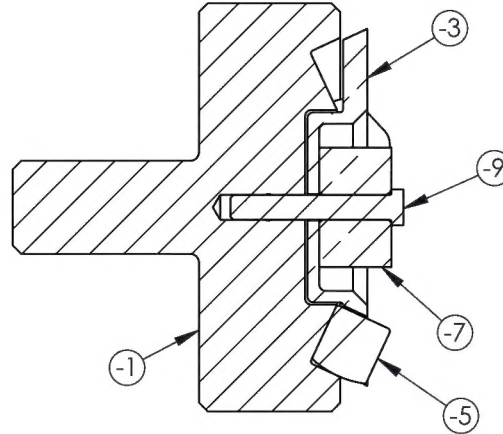
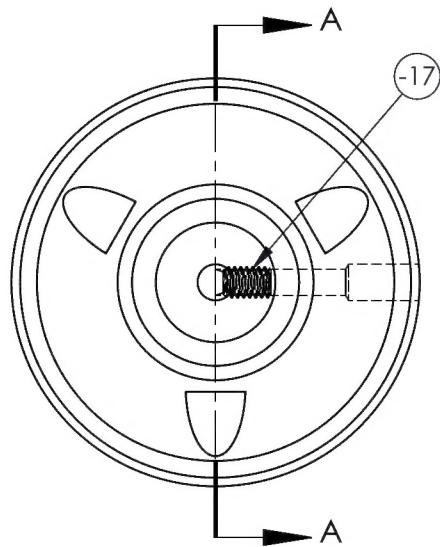
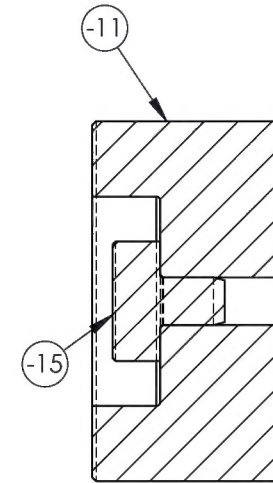


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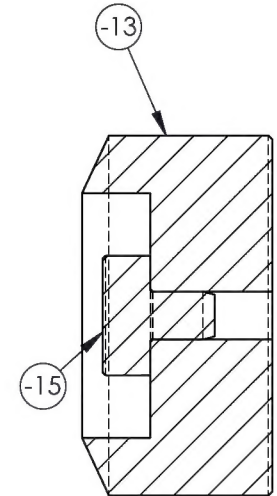
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED -3 MISSING 25° DIMENSION.	1/16/12	RJC	SE



SECTION A-A



PRIMARY SEAT



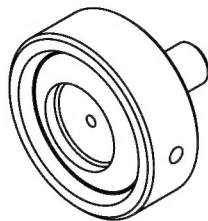
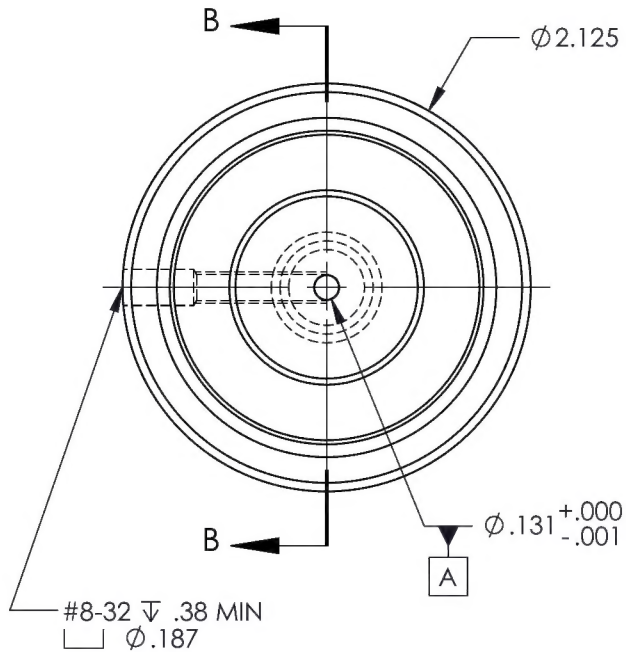
SECONDARY SEAT

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	DRILL ROD	Ø2-1/8 X 1-7/8	2
			-3	1	RETAINER	BRONZE RND BAR	Ø1-7/8 X 1/4	3
			-5	3	ROLLER	STEEL	GAUGE PIN MSC #89031009	4
			-7	1	GUIDE	BRONZE RND BAR	Ø5/8 X 3/8	5
			-9	1	PIN	MCMaster-CARR #98378A909	MCMaster-CARR #98378A909	6
			-11	1	PRIMARY SEAT	4140 Q & T	Ø1-7/8 X 1-1/8	7
			-13	1	SECONDARY SEAT	4140 Q & T	Ø1-7/8 X 1-1/8	8
			-15	1	LOCATING PIN	1018	Ø5/8 X 3/4	9
		B/O	-17	1	SOCKET HEAD CAP SCREW	S.S.	#8-32 X 1/4 (MCMaster-CARR #97705A406)	1

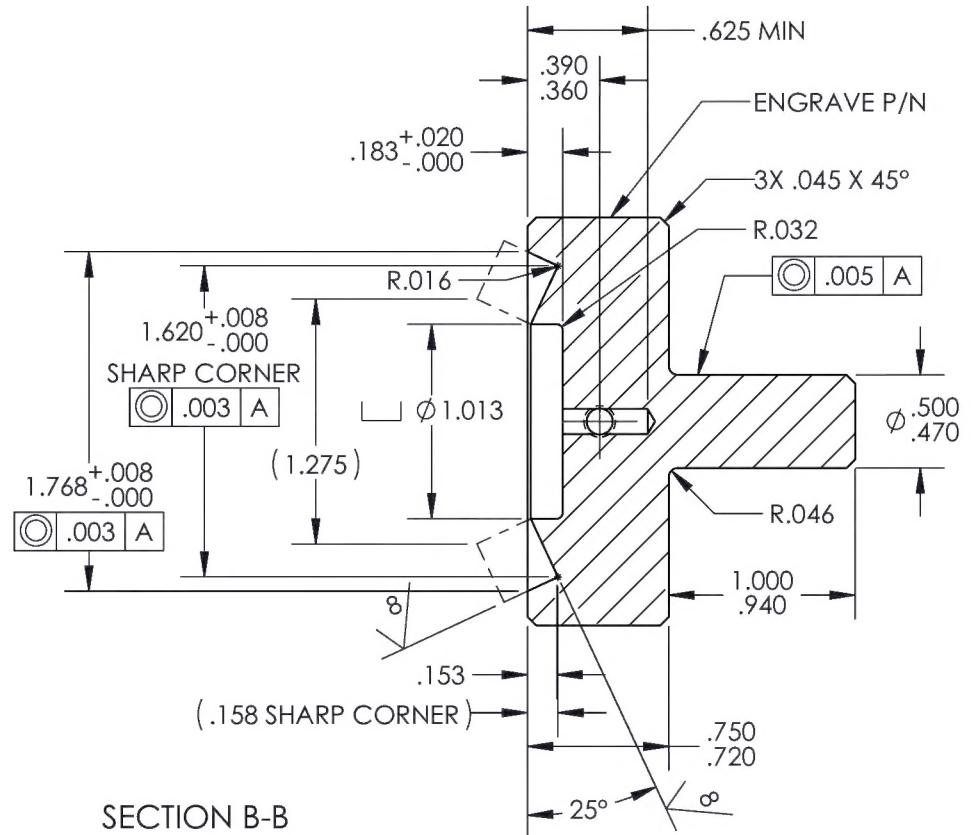
<b>RED BARN MACHINE</b>	
<b>TITLE</b> <b>TRI-ROLLER SWAGING TOOL</b>	
<b>DWG NO.</b> <b>RBST1035</b>	<b>REV</b> <b>A</b>
<b>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</b> <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> GILBERT <b>APPROVED</b> <i>D Weil</i> <b>HEAT TREAT</b> <b>FINISH</b> <b>SPEC</b>
<b>UNLESS OTHERWISE SPECIFIED</b> <b>1. BREAK ALL SHARP EDGES</b> .015 x 45° PR .015 R <b>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</b>	<b>USED ON MODEL</b> <b>KR10-CEG</b>
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 1 OF 9</b>	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



(-1)  
ROLLER  
FIXTURE



SECTION B-B

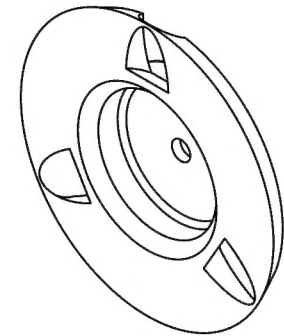
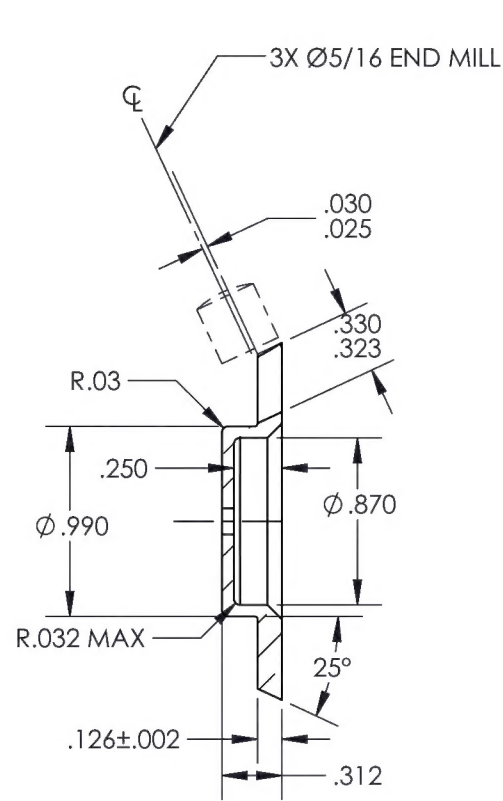
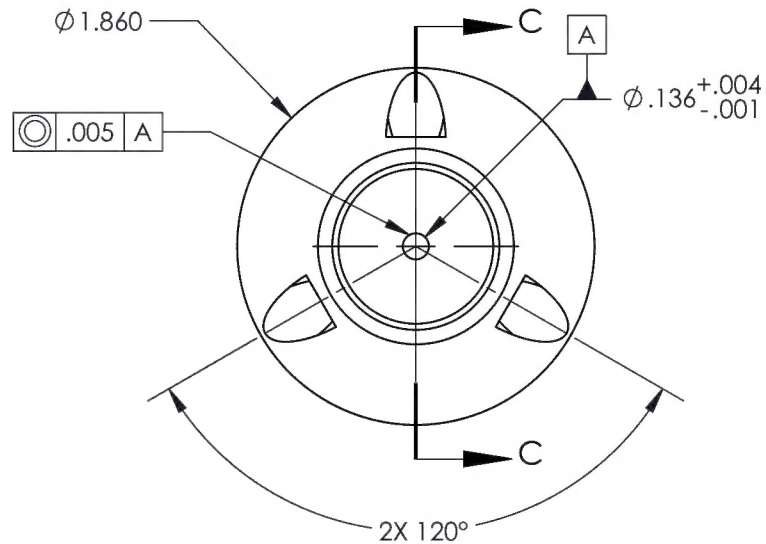
NOTES:

1. ROLLER RACE SURFACES MUST HAVE SMOOTH APPEARANCE, FREE FROM MACHINING MARKS AND GROOVES.
2. DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.

<b>RED BARN MACHINE</b>	
TITLE <b>TRI-ROLLER SWAGING TOOL</b>	
DWG NO. <b>RBST1035-1</b>	REV <b>A</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: <b>GILBERT</b> APPROVED: <i>D. Weil</i> HEAT TREAT: <b>RC 55-60</b> FINISH: <b>BLACK OXIDE</b> SPEC: <b>USED ON MODEL</b> <b>KR10-CEG</b>	
SCALE <b>1:1</b>	DATE <b>3/28/2011</b>
SHEET 2 OF 9	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED -3 MISSING 25° DIMENSION.	1/16/12	RJC	SE



SECTION C-C

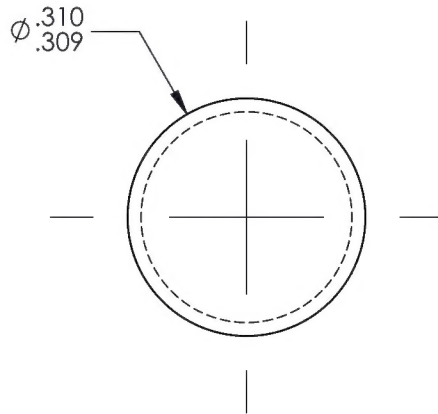
(-3)

RETAINER

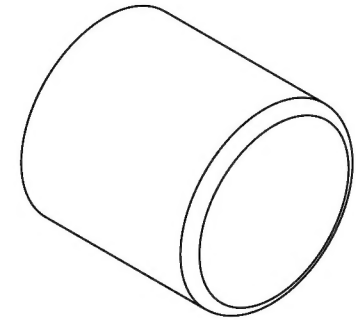
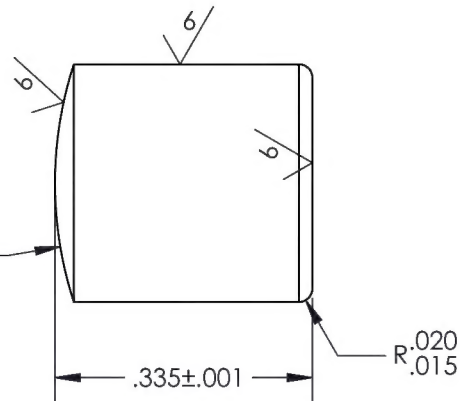
 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TR-ROLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-3	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL KR10-CEG	
SCALE 1:1	DATE 3/28/2011
SHEET 3 OF 9	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED



R.502  
R.480  
SPHERICAL



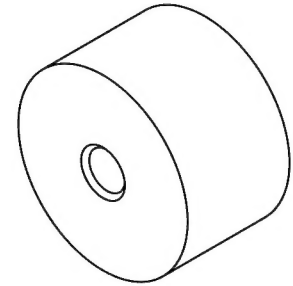
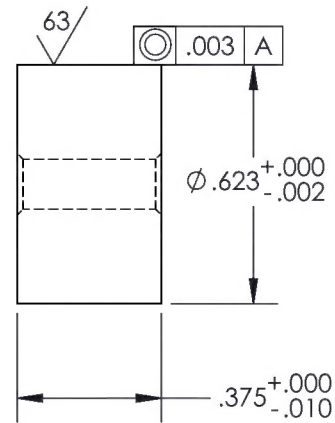
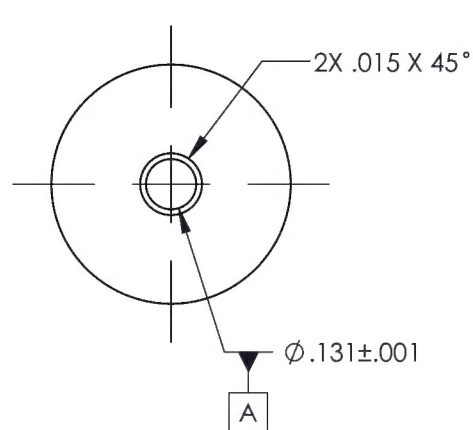
(-5)

ROLLER

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRI-ROLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-5	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> GILBERT <b>APPROVED:</b> <i>D. Weil</i> <b>HEAT TREAT:</b> RC 55-60 <b>FINISH:</b> <b>SPEC:</b>
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	<b>USED ON MODEL:</b> KR10-CEG
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 4 OF 9</b>	

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REV	DESCRIPTION	DATE	INITIAL
			APPROVED

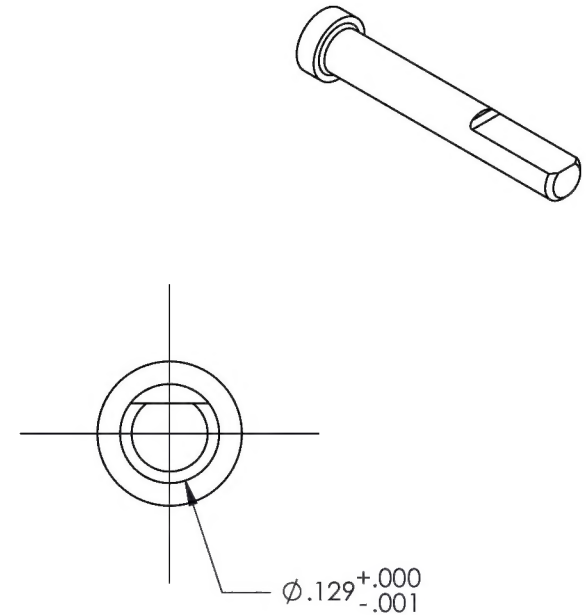
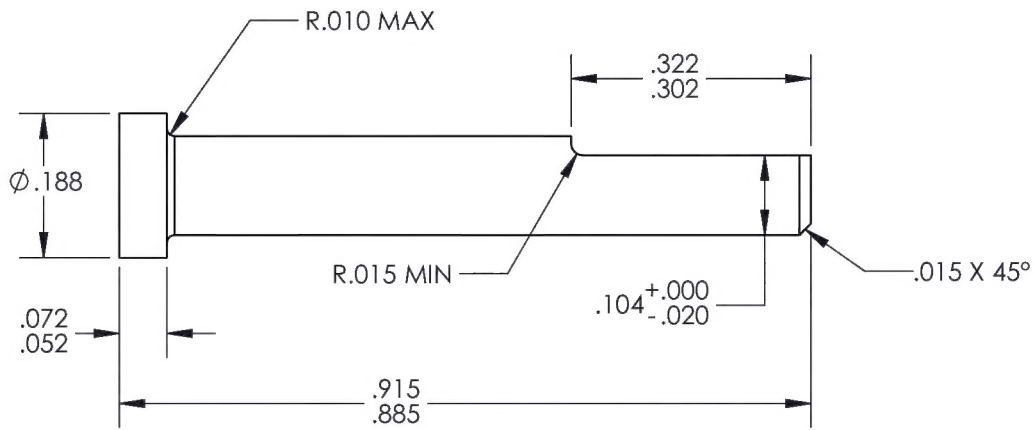


GUIDE

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRI-ROLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-7	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> GILBERT <b>APPROVED:</b> <i>D Weil</i> <b>HEAT TREAT:</b> <b>FINISH:</b> <b>SPEC:</b>
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	<b>USED ON MODEL</b> KR10-CEG
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 5 OF 9</b>	


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED



-9

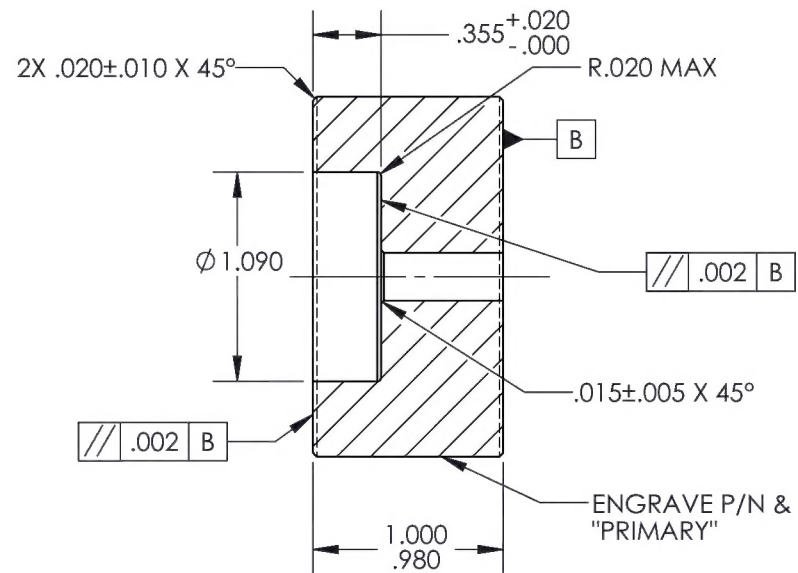
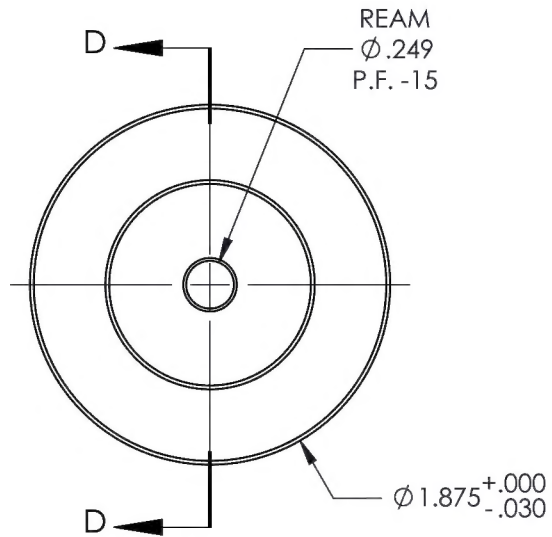
PIN

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRI-ROLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-9	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX $\pm .005$ .XX $\pm .01$ .X $\pm .1$ FRACTIONS $\pm 1/32$ ANGLES $\pm 5^\circ$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 6 OF 9</b>	
<b>DRAWN BY:</b> GILBERT <b>APPROVED:</b> <i>D Weil</i> <b>HEAT TREAT:</b> BLACK OXIDE <b>SPEC:</b> USED ON MODEL KR10-CEG	



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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION D-D

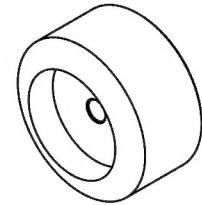
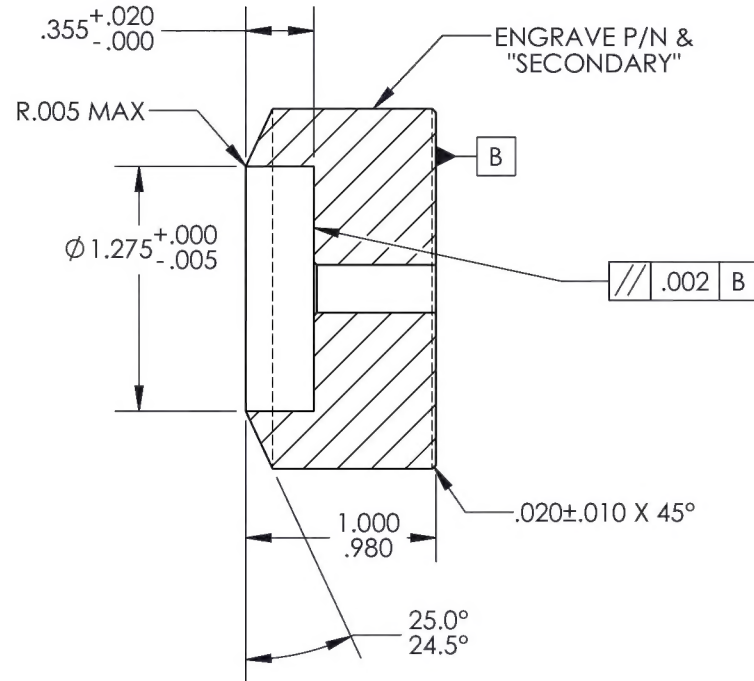
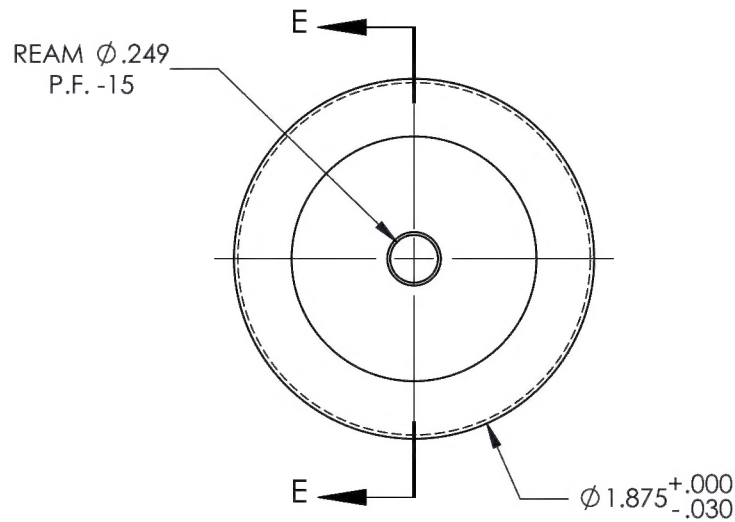
(11)

PRIMARY SEAT

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRI-ROLLER SWAGGING TOOL	
<b>DWG NO.</b> RBST1035-11	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX $\pm$ .005 .XX $\pm$ .01 .X $\pm$ .1 FRACTIONS $\pm$ 1/32 ANGLES $\pm$ 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 7 OF 9</b>	
<b>DRAWN BY:</b> APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL KR10-CEG	


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED



# SECTION E-E

(-13)  
SECONDARY  
SEAT

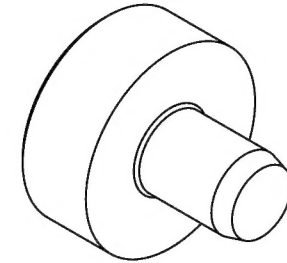
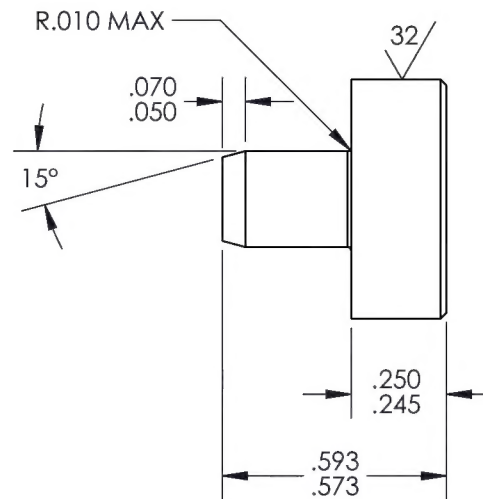
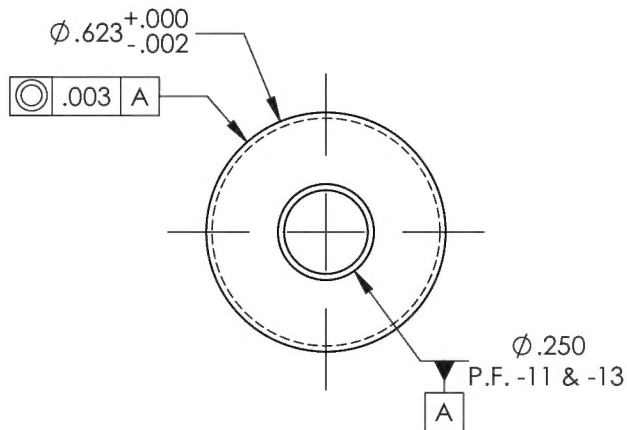
 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRI-ROLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-13	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> 1:1	<b>DATE</b> 3/28/2011
<b>SHEET 8 OF 9</b>	

<b>DRAWN BY:</b> GILBERT
<b>APPROVED</b> <i>D Weil</i>
<b>HEAT TREAT</b>
<b>FINISH</b> BLACK OXIDE
<b>SPEC</b>
<b>USED ON MODEL</b>
<b>KR10-CEG</b>



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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



(-15)  
LOCATING PIN

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TRIOLLER SWAGING TOOL	
<b>DWG NO.</b> RBST1035-15	<b>REV</b> A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES <b>TOLERANCES ON:</b> DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH: BLACK OXIDE SPEC USED ON MODEL KR10-CEG	
SCALE: 1:1	DATE: 3/28/2011
SHEET 9 OF 9	